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(54) **Anionic compounds**

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Composés anioniques

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(73) Proprietor: **ZENECA LIMITED**  
**London W1Y 6LN (GB)**

(72) Inventors:  
• **Gregory, Peter**  
**Bolton BL3 4 UN (GB)**

• **Kenyon, Ronald Wynford**  
**Fallsworth, Manchester M35 0GW (GB)**

(74) Representative: **Pugsley, Roger Graham et al**  
**Intellectual Property Group**  
**Zeneca Specialties**  
**P.O. Box 42**  
**Hexagon House**  
**Blackley**  
**Manchester M9 8ZS (GB)**

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**US-A- 4 474 696**                      **US-A- 4 843 150**

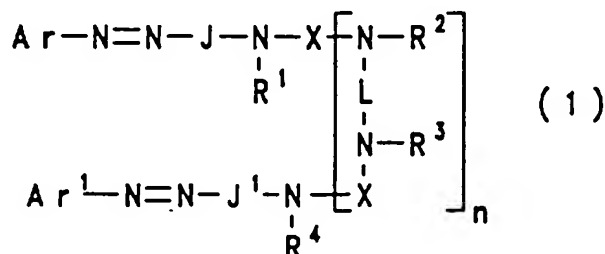
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**EP 0 468 647 B1**

## Description

This specification describes an invention relating to anionic compounds and particularly to anionic azo compounds which are useful as the coloured component of inks, particularly inks used in ink jet printing.

According to the present invention there are provided anionic azo compounds which, in the free acid form, have the structure shown in Formula (1):



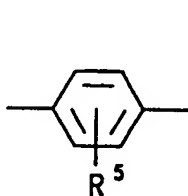
wherein:

Ar and Ar<sup>1</sup>

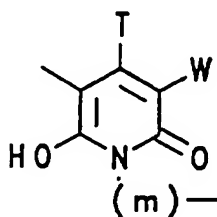
are each independently aryl or substituted aryl providing at least one of Ar and Ar<sup>1</sup> has at least one substituent selected from COOH and COSH;

J and J<sup>1</sup>

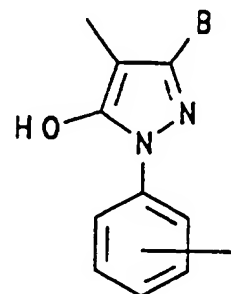
are each independently of formula (2), (3) or (4):



(2)



(3)



(4)

each R<sup>5</sup>

is independently selected from H, alkyl, substituted alkyl, alkoxy, halogen, CN, ureido and NHCOR<sup>6</sup>;

R<sup>6</sup>

is H, alkyl, substituted alkyl, aryl, substituted aryl, aralkyl or substituted aralkyl;

each T

is independently alkyl;

each W

is independently selected from H, CN, CONR<sup>10</sup>R<sup>11</sup>, pyridinium and COOH;

each m

is an alkylene chain having 2 to 8 carbon atoms;

B

is H, alkyl or COOH;

R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, R<sup>10</sup> and R<sup>11</sup>

are each independently H, alkyl or substituted alkyl;

L

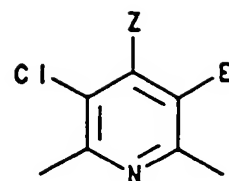
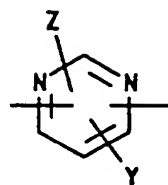
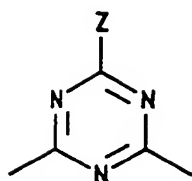
is a divalent organic linking group;

n

is 0 or 1;

each X

is independently carbonyl or a group of the Formula (5), (6) or (7):



( 5 )

( 6 )

( 7 )

Z is  $OR^7$ ,  $SR^7$  or  $NR^8R^9$ ;

Y is H, Cl, CN or Z;

E is Cl or CN;

$R^7$ ,  $R^8$  and  $R^9$  are independently H, alkenyl, substituted alkenyl, alkyl, substituted alkyl, aryl, substituted aryl, aralkyl or substituted aralkyl, or  $R^8$  and  $R^9$  together with the nitrogen atom to which they are attached form a 5 or 6 membered ring;

provided (i) if the compound of Formula (1) has no  $-SO_3H$  groups then it has at least two groups selected from  $-COOH$  and  $-COSH$ ; and (ii) the compound of Formula (1) has at least as many groups selected from  $-COOH$  and  $-COSH$  as  $-SO_3H$  groups.

It is preferred that the compound of Formula (1) has at least as many  $-COOH$  as  $-SO_3H$  groups and if the compound of Formula (1) has no  $-SO_3H$  groups then it has at least two and more preferably at least three  $-COOH$  groups.

It is preferred that  $Ar-N=N-J$  and  $Ar-N=N-J^1$  are such that the compounds of Formula (1) are yellow. It is also preferred that compounds of Formula (1) are free from cellulose reactive groups.

The groups Ar and  $Ar^1$  are preferably independently selected from naphthyl, substituted naphthyl, phenyl and substituted phenyl, especially phenyl and substituted phenyl. The optional substituents on Ar and  $Ar^1$  are preferably selected from alkyl, especially  $C_{1-4}$ -alkyl; substituted  $C_{1-4}$ -alkyl; alkoxy, especially  $C_{1-4}$ -alkoxy;  $-SO_3H$ ;  $-PO_3H_2$ ;  $-COSH$ ;  $-OH$ ;  $-CO_2H$ ; halogen, especially Cl or Br. It is particularly preferred that when Ar and  $Ar^1$  are substituted the substituents are independently selected from  $CO_2H$ ,  $COSH$  and  $SO_3H$ , especially  $CO_2H$ . In especially preferred structures, at least one of Ar and  $Ar^1$  has at least one  $-COOH$  substituent but it is even more preferred that each of Ar and  $Ar^1$  has at least one  $-COOH$  substituent and more particularly at least two  $-COOH$  substituents as in, for example, dicarboxyphenyl.

Each  $R^5$  is preferably independently selected from H,  $C_{1-4}$ -alkyl, substituted  $C_{1-4}$ -alkyl,  $C_{1-4}$ -alkoxy, Cl, CN, Br, ureido or  $NHCO R^6$ , more preferably H,  $C_{1-4}$ -alkyl,  $C_{1-4}$ -alkoxy, ureido or  $NHCO(C_{1-4}$ -alkyl), especially H, methyl, methoxy or ureido. Each  $R^5$  is preferably ortho with respect to the azo group connected to the same ring.

$R^6$  is preferably H,  $C_{1-4}$ -alkyl, phenyl or  $(CH_2)_{1-4}$ -phenyl, all of which are either unsubstituted or substituted.  $R^6$  is more preferably  $C_{1-4}$ -alkyl.

Each T is preferably independently  $C_{1-6}$ -alkyl, especially  $C_{1-4}$ -alkyl.

The group (m) present in Formula (3) is branched chain alkylene or preferably straight chain alkylene.

B is preferably H.

When X is of Formula (6) it is preferred that Z is attached to the carbon atom between the two ring nitrogen atoms and that Y is para with respect to Z. Each X independently is preferably of Formula (5).

Z is preferably  $NR^8R^9$ , especially  $NHC_2H_4OH$ ,  $N(C_2H_4OH)_2$ , morpholino,  $NH(C_{1-6}$ -alkyl),  $NH-(CH_2)_2-CO_2H$ ,  $NHCH_2C_6H_4CO_2H$ , mono- or di-carboxyanilino,  $NHC_6H_4SO_3H$  or  $NHCH_2SO_3H$ .

$R^1$ ,  $R^2$ ,  $R^3$  and  $R^4$  are preferably independently selected from H,  $C_{1-4}$ -alkyl and  $C_{1-4}$ -alkyl substituted by OH.

$R^7$ ,  $R^8$  and  $R^9$  are preferably independently selected from H,  $C_{1-6}$ -alkyl, substituted  $C_{1-6}$ -alkyl,  $C_{3-4}$ -alkenyl, phenyl, substituted phenyl,  $(CH_2)_{1-4}$ -phenyl, substituted  $(CH_2)_{1-4}$ -phenyl, more preferably H, allyl,  $C_{1-4}$ -alkyl, benzyl, hydroxy  $C_{1-4}$ -alkyl especially H, methyl, ethyl and 2-hydroxyethyl. The optional substituents on  $R^7$ ,  $R^8$  and  $R^9$  are preferably independently selected from  $-OH$ ,  $-SO_3H$  and  $-COOH$ , especially  $-OH$ . When  $R^8$  and  $R^9$  together with the nitrogen atom to which they are attached form a 5 or 6 membered ring they preferably form a morpholine, piperazine or piperidine ring.

The identity of the divalent organic linking group L is not critical providing it does not interfere with the performance of the compound. As examples of divalent organic linking groups represented by L there may be mentioned:

(a) divalent aliphatic radicals, preferably those containing from 2 to 6 carbon atoms, such as ethylene, trimethylene, propylene, tetramethylene, alpha:beta-dimethylethylene and hexamethylene radicals;

(b) divalent aromatic homocyclic radicals in which at least one of the terminal links is through an aliphatic carbon

atom, for example as in the benzylene  $-C_6H_4-CH_2-$  or the xylylene  $-CH_2C_6H_4CH_2-$  group;

(c) divalent monocyclic or fused polycyclic aromatic radicals, for example of the benzene, naphthalene, anthraquinone or fluorene series, such as

1,3- or 1,4-phenylene	2-nitro-1,4-phenylene
3-sulpho-1,4-phenylene	4-methoxy-1,3-phenylene
4-sulpho-1,3-phenylene	4-nitro-1,3-phenylene
2-carboxy-1,4-phenylene	2-chloro-1,4-phenylene
4-carboxy-1,3-phenylene	3,7-disulpho-1,5-naphthylene
2-methoxy-1,4-phenylene;	

(d) divalent radicals wherein the terminal bonds are attached to carbon atoms of two phenyl or naphthalene nuclei which are joined together either through a direct link or through an atom or chain of atoms which may form a homocyclic or heterocyclic ring. Of this type, there may be mentioned as examples divalent radicals derived from

diphenyl	azobenzene
diphenyloxide	diphenyloxadiazole
diphenylamine	benzanilide
diphenylsulphide	diphenylurea
diphenylsulphone	1,2-bis(phenylcarbonyl)ethylene
diphenylmethane	1,4-bis-(phenylcarbonyl)butadiene
diphenylketone	1,2-bis-(phenylcarbonyl)ethane
diphenylethane	1,3-bis-(phenylcarbonyl)propane
diphenylethylene	2,4-dianilino-s-triazine;

and

(e) nuclear substituted derivatives of the above, for example, containing  $COOH$ , methyl, nitro and/or sulphonic acid and/or chlorine atoms as substituents in the phenyl or naphthalene nuclei.

Alternatively the group  $NR^2LNR^3$  can be piperazino in which the two ring nitrogen atoms are bonded to the groups represented by X.

It is to be understood that the present invention relates not only to compounds of Formula (1) but also to the salts thereof, particularly the salt with an alkali metal, ammonia or substituted amines, especially ammonia and substituted amines which are volatile at room temperature. It is also to be understood that whilst Formulae (3) and (4) above are represented in neutral form, the present invention also covers quaternary salts of Formulae (3) and (4), particularly when the compound of Formula (1) is in zwitterionic form.

According to a further aspect of the present invention there is provided a process for the preparation of compounds of Formula (1) comprising

(i) diazotisation of amines of the formulae  $ArNH_2$  and  $Ar^1NH_2$  with a diazotising agent such as  $HNO_2$ , in the cold and preferably below  $5^\circ C$  to give the corresponding diazonium salts;

(ii) coupling the diazonium salt formed from  $ArNH_2$  with an amine of formula  $H-J-NR^1H$ , and coupling the diazonium salt formed from  $Ar^1NH_2$  with an amine of formula  $H-J^1-NR^4H$  to give monoazo amines;

(iii) reacting the monoazo amines of step (ii) in either order or simultaneously with a compound of formula

$Cl-X-(NR^2-L-NR^3-X)_n-Cl$ , preferably in the presence of base; wherein Ar,  $Ar^1$ , X,  $R^1$  to  $R^4$ , J,  $J^1$ , L and n are as defined above unless stated otherwise.

Alternatively, step (iii) may be followed except that in the definition of X above, instead of the substituent Z there is Cl, and the product of step (iii) is reacted with a compound of formula ZH (wherein Z is as hereinbefore defined) to give a compound of Formula (1).

As Examples of amines of formulae  $ArNH_2$  and  $Ar^1NH_2$  which may be used in the preparation of compounds of Formula (1), there may be mentioned

2-aminoisophthalic acid	3-amino-4-fluorobenzoic acid
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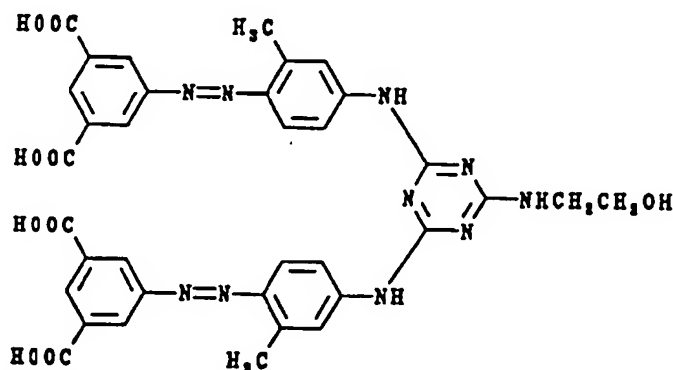
4-aminoisophthalic acid	3-amino-5-hydroxybenzoic acid
5-aminoisophthalic acid	3-amino-4-hydroxybenzoic acid
3-aminophthalic acid	3-amino-2-hydroxybenzoic acid
4-aminophthalic acid	2-amino-6-hydroxybenzoic acid
2-aminoterephthalic acid	2-amino-4-nitrobenzoic acid
3-aminobenzoic acid	3-amino-5-nitrobenzoic acid
4-aminobenzoic acid	2-nitro-3-aminobenzoic acid
anthranilic acid	2-nitro-5-aminobenzoic acid
4-sulphoanthranilic acid	3-nitro-4-aminobenzoic acid
5-sulphoanthranilic acid	3-acetyl-amino-5-aminobenzoic acid
2-amino-4-chlorobenzoic acid	3-amino-4-methylbenzoic acid
2-amino-5-chlorobenzoic acid	2-amino-3-methylbenzoic acid
3-amino-4-chlorobenzoic acid	3-amino-4-methoxybenzoic acid
5-amino-2-chlorobenzoic acid	3-amino-4-hydroxybenzoic acid
2-amino-5-methylbenzoic acid	4-aminosalicylic acid
2-amino-6-methylbenzoic acid	5-aminosalicylic acid
2-amino-5-bromobenzoic acid	3-amino-2-naphthoic acid
2-n-butoxy-4-aminobenzoic acid	5-amino-2-naphthoic acid
	8-amino-2-naphthoic acid

The compounds of Formula (1) are especially useful for the preparation of inks, especially aqueous inks, used in ink jet printing and particularly thermal ink jet printing. The inks can be prepared according to known formulations.

The invention is further illustrated by the following Examples in which all parts and percentages are by weight unless otherwise indicated.

#### Example 1

Preparation of



5-aminoisophthalic acid (36.2g) was stirred in water (1 litre) and the pH adjusted to 8-9 by addition of 2N sodium hydroxide. Sodium nitrite (14g) was added and the solution added to a mixture of concentrated hydrochloric acid (60ml) and water (500ml) at 0-10°C. After 1 hour at 0-10°C the excess nitrous acid was removed by addition of a little sulphamic acid, to give a diazo suspension.

m-toluidine (21.4g) was added to water (500ml) and concentrated hydrochloric acid (25ml) added. The solution was added over ½ hour to the above diazo suspension at 0-10°C. The pH was adjusted to 4.0 by addition of 47% sodium hydroxide solution and the mixture stirred for 18 hours at 0-10°C. The pH was adjusted to 8.0 with 47% sodium hydroxide solution, screened and then warmed to 60°C. It was slowly acidified to pH 4.0 with concentrated hydrochloric acid and the product filtered, washed with water and dried to give a monoazo compound.

8.87g (one equivalent) of the above monoazo compound was added to water (500ml) and the pH adjusted to 8.0 by addition of 47% sodium hydroxide solution. It was cooled to 0-10°C and a solution of cyanuric chloride (4.61g, one equivalent) in acetone (50ml) added maintaining the pH at 7-8 and a temperature of 0-10°C. After ½ hour a further

solution of one equivalent of the above monoazo compound (8.87g) in water (500ml) at pH 8.0 was added and the reaction mixture warmed to 45°C and stirred at this temperature for 4 hours maintaining the pH at 7-8.

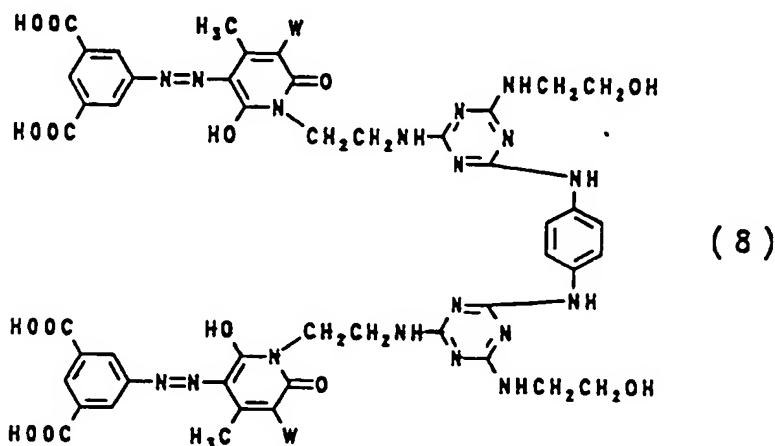
2-Aminoethanol (10g) was then added and the mixture heated to 80°C. After stirring at 80°C for 2 hours the pH was adjusted to 7.0 and salted to 20% using sodium chloride. The product was filtered and washed with saturated brine.

The above product was dissolved in water (1 litre) and the solution added to 2N hydrochloric acid to precipitate the title product in free acid form. The title product was filtered, washed and added to water (200ml). The pH was adjusted to 9.0 with concentrated ammonium hydroxide and the solution dialysed to remove chloride ions, screened and evaporated to give the ammonium salts of the title product. Yield = 10g.

When made into an ink by dissolving in water/diethylene glycol (92.5/7.5) and printed onto plain paper using a thermal ink-jet printing machine the ammonium salt of the title compound gave bright yellow shades with excellent water fastness and good light fastness. The same water/diethylene glycol mixture was used as the solvent in the inks described in subsequent Examples.

### Example 2

Preparation of the compound of Formula (8) in which W is H



5-aminoisophthalic acid (9.05g) was stirred in water (150ml) and the pH adjusted to 8-9 by addition of 2N sodium hydroxide solution. 2N Sodium nitrite (25ml) was added and the solution added to a mixture of concentrated hydrochloric acid (25ml) and water (200ml) at 0-5°C. After 2 hours the excess nitrous acid was removed by addition of a little sulphamic acid, to give a solution of diazonium salt.

A mixture of 1-(2-aminoethyl)-6-hydroxy-4-methylpyridin-2-one (8.4g), water (300ml), sodium acetate (12.5g) and 2N sodium hydroxide (40ml) was stirred at 0-5°C and the above solution of diazonium salt added at 0-5°C. The mixture was stirred for 18 hours at 0-5°C. It was filtered, washed with water and dried to give 20.5g of azo pyridone compound.

18.0g of the above azo pyridone compound was stirred in water (300ml) and cooled to 0-5°C. A solution of cyanuric chloride (10g, one equivalent) in acetone (100ml) was added at 0-5°C maintaining the pH at 7-8 by addition of 2N sodium hydroxide. After 3 hours the temperature was raised to 20-25°C and a solution of 1,4-phenylenediamine (2.16g, ½ equivalent) in acetone (25ml) added, maintaining the pH at 7-8. The mixture was stirred for 18 hours at 20-25°C maintaining the pH at 7-8.

The mixture was then acidified to pH 5 with concentrated hydrochloric acid, filtered, washed and dried to give 24.6g of a bis(monochlorotriazine) intermediate compound.

11.46g of the bis(monochlorotriazine) intermediate compound was stirred in water (150ml) and 2-aminoethanol (9.2g) added. The mixture was heated to 65°C and stirred at 65-70°C for 12 hours. It was then acidified to pH 5, sodium chloride (30g) added, and the product filtered off.

The product was then added to water (150ml) and the pH adjusted to 9.0 with sodium hydroxide solution. The solution was added to a mixture of concentrated hydrochloric acid (20ml) and water (200ml) to precipitate the title compound in free acid form.

The title compound was filtered off and converted to the ammonium salt by adding to water (250ml) and adjusting the pH to 9.0 by addition of concentrated ammonium hydroxide.

The solution was dialysed to remove chloride ions, screened and evaporated to give the ammonium salt of the title compound. Yield = 8.0g.

When made into an ink and printed onto plain paper using a thermal ink-jet printing machine the ammonium salt of the title compound gave bright yellow shades with excellent water fastness and good light fastness.

### Example 3

#### Preparation of the compound of Formula (8) in which W is CN

In place of the 8.4g of 1-(2-aminoethyl)-6-hydroxy-4-methylpyrid-2-one used in Example 2 there was used 8.95g of 1-(2-aminoethyl)-3-cyano-6-hydroxy-4-methylpyrid-2-one. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave yellow shades having excellent water fastness.

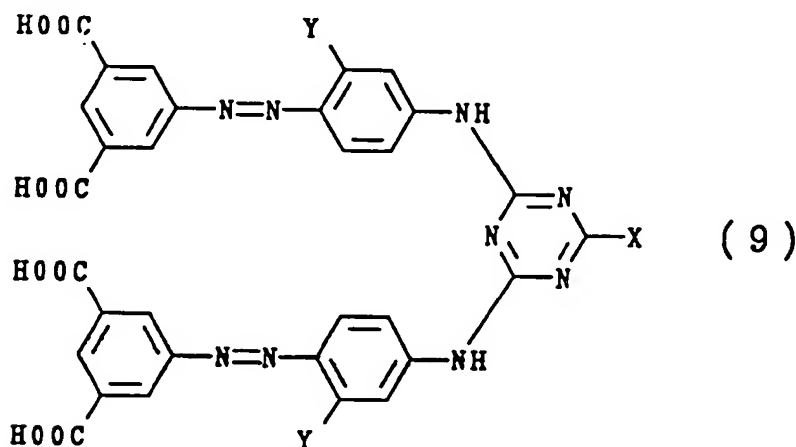
### Example 4

#### Preparation of the compound of Formula (8) in which W is CONH<sub>2</sub>

In place of the 8.4g of 1-(2-aminoethyl)-6-hydroxy-4-methylpyrid-2-one used in Example 2 there was used 10.55g of 1-(2-aminoethyl)-3-carbamido-6-hydroxy-4-methylpyrid-2-one. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave yellow shades having excellent water fastness.

### Example 5

#### Preparation of the compound of Formula (9) in which X is N(C<sub>2</sub>H<sub>4</sub>OH)<sub>2</sub> and Y is CH<sub>3</sub>



In place of the 10g of 2-aminoethanol used in Example 1 there was used 17.2g of diethanolamine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave yellow shades having excellent water fastness.

### Example 6

#### Preparation of the compound of Formula (9) in which X is morpholino and Y is CH<sub>3</sub>

In place of the 10g of 2-aminoethanol used in Example 1 there was used 14.3g of morpholine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave yellow shades having excellent water fastness.

Example 7

Preparation of the compound of Formula (9) in which X is OH and Y is CH<sub>3</sub>

5 In place of the 10g of 2-aminoethanol used in Example 1 there was used 6.5g of sodium hydroxide. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave yellow shades having excellent water fastness.

Example 8

10

Preparation of the compound of Formula (9) in which X is NHCH<sub>2</sub>CH<sub>2</sub>OH and Y is H

5-Aminoisophthalic acid (36.2g) was diazotised as in Example 1.

15 Aniline  $\omega$ -methane sulphonate (70g) was added to water (400ml) to dissolve. The solution was added to the above diazo suspension at 0-10°C and pH 7. The mixture was then stirred for 18 hours at 20°C.

The product was salted to 20% using sodium chloride, stirred for 2 hours, acidified to pH 4 with concentrated hydrochloric acid and then filtered.

20 The paste was added to a mixture of water (2 l) and sodium hydroxide (80g) and heated at 70-80°C for 3 hours. It was cooled to 20°C and salted to 20% using sodium chloride and acidified to pH 3 using concentrated hydrochloric acid. The product was filtered and dried to give the monoazo compound.

7.62g (one equivalent) of the above monoazo compound was added to water (500ml) and the pH adjusted to 8 by addition of 2N sodium hydroxide solution. It was cooled to 0-10°C and a solution of cyanuric chloride (50g; one equivalent) in acetone (50ml) added maintaining the pH at 7 and a temperature of 0-10°C. After 1 hour a further solution of one equivalent of the above monoazo compound (7.62g) in water (500ml) at pH 8.0 was added and the reaction mixture warmed to 30°C and stirred for 18 hours at 25-30°C. The pH was adjusted to 5.0 with concentrated hydrochloric acid and the product filtered.

It was slurried in water (500ml) and 2-aminoethanol (10g) added and the mixture heated to 80°C. After stirring at 80°C for 4 hours the product was salted to 30% with ammonium chloride and the mixture cooled to 20°C. The product was filtered and washed with saturated ammonium chloride solution.

30 The above product was dissolved in water (400ml) by addition of concentrated ammonium hydroxide solution and added to a mixture of water (200g) and concentrated hydrochloric acid (30g) to precipitate the title compound in free acid form. It was filtered, washed and added to water (200ml). The pH was adjusted to 9.0 with concentrated ammonium hydroxide solution and the solution dialysed to remove chloride ions, screened and evaporated.

35 The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink jet printing machine gave bright yellow shades with very good water fastness.

Example 9

Preparation of the compound of Formula (9) in which X is N(C<sub>2</sub>H<sub>4</sub>OH)<sub>2</sub> and Y is H

40

In place of the 10g of 2-aminoethanol used in Example 8 there was used 15.75g of diethanolamine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with very good water fastness.

45 Example 10

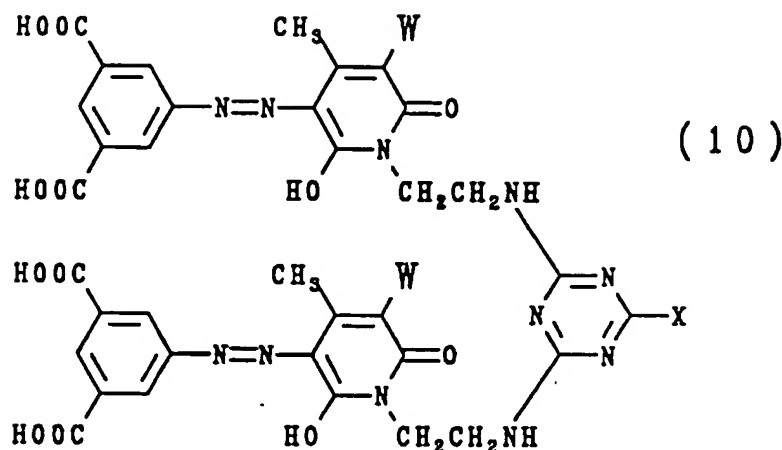
Preparation of the compound of Formula (9) in which X is morpholino and Y is H

50 In place of the 10g of 2-aminoethanol used in Example 8 there was used 14.3g of morpholine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with very good water fastness.

Example 11

55 Preparation of the compound of Formula (10) in which W is H and X is NHCH<sub>2</sub>CH<sub>2</sub>OH





5-Aminoisophthalic acid was diazotised and coupled onto 1-(2-aminoethyl)-6-hydroxy-4-methylpyrid-2-one as in Example 2. It was then condensed with one equivalent of cyanuric chloride as in Example 2. A further equivalent of monoazo compound was then added, the temperature raised to 45°C and the pH maintained at 7-8 for 4 hours.

2-Aminoethanol (5g) was then added and the mixture heated at 65-70°C for 6 hours.

The reaction mixture was cooled to 20°C and the pH adjusted to 5 with concentrated hydrochloric acid. The product was filtered and reslurried in water (150ml) and the pH adjusted to 9.0 with sodium hydroxide solution. The solution was added to a mixture of water (200ml) and concentrated hydrochloric acid (20ml) to precipitate the title compound in free acid form.

It was filtered off and converted to the ammonium salt by adding to water (250ml) and adjusting the pH to 9.0 by addition of concentrated ammonium hydroxide.

The solution was dialysed to remove chloride ions, screened and evaporated.

When made into an ink and printed onto plain paper using a thermal ink jet printing machine it gave bright yellow shades with excellent water fastness.

#### Example 12

Preparation of the compound of Formula (9) in which X is N(CH<sub>3</sub>)C<sub>2</sub>H<sub>4</sub>OH and Y is H

In place of the 10g of 2-aminoethanol used in Example 8 there are used 12.3g of 2-(methylamino)ethanol. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gives bright yellow shades with very good water fastness.

#### Example 13

Preparation of the compound of Formula (9) in which X is N(C<sub>2</sub>H<sub>5</sub>)C<sub>2</sub>H<sub>4</sub>OH and Y is H

In place of the 10g of 2-aminoethanol used in Example 8 there are used 14.6g of 2-(ethylamino)ethanol. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gives bright yellow shades with very good water fastness.

#### Example 14

Preparation of the compound of Formula (9) in which X is NH.nC<sub>4</sub>H<sub>9</sub> and Y is H

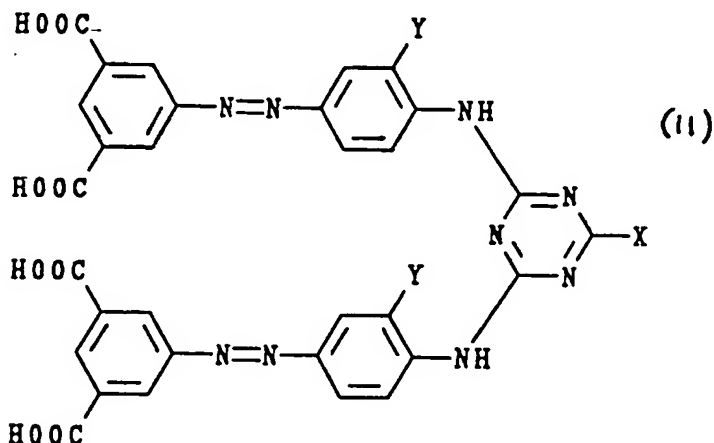
In place of the 10g of 2-aminoethanol used in Example 8 there was used 12g of n-butylamine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with very good water fastness.

Example 15Preparation of the compound of Formula (9) in which X is  $\text{NH-nC}_6\text{H}_{13}$  and Y is H

In place of the 10g of 2-aminoethanol used in Example 8 there was used 16.6g of n-hexylamine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with very good water fastness.

Example 16Preparation of the compound of Formula (9) in which X is  $\text{NH(CH}_2)_6\text{OH}$  and Y is H

In place of the 10g of 2-aminoethanol used in Example 8 there was used 19.2g of 6-amino-1-hexanol. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with very good water fastness.

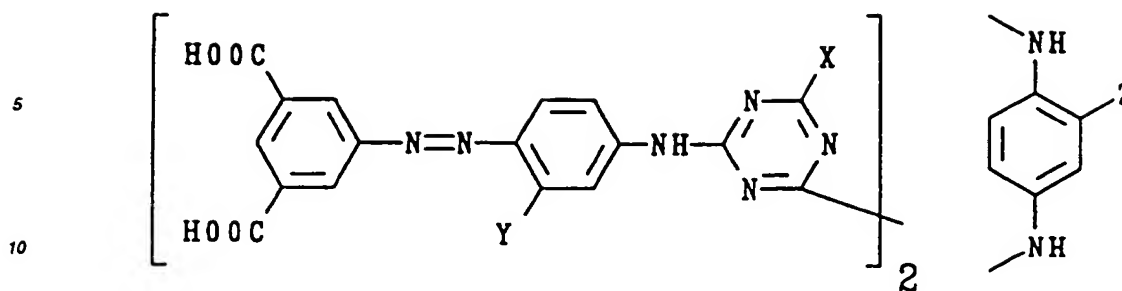
Example 17Preparation of the compound of Formula (11) in which X is  $\text{NHCH}_2\text{CH}_2\text{OH}$  and Y is  $\text{OCH}_3$ 

In place of the 70g of aniline- $\omega$ -methane sulphonate used in Example 8 there was used 81.2g of o-anisidine- $\omega$ -methane sulphonate. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with very good water fastness.

Example 18Preparation of the compound of Formula (11) in which X is morpholino and Y is  $\text{OCH}_3$ 

In place of the 10g of 2-aminoethanol used in Example 17 there was used 14.3g of morpholine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with good water fastness.

Example 19Preparation of the compound of Formula (12) in which X is  $\text{NHCH}_2\text{CH}_2\text{OH}$ , Y is  $\text{CH}_3$  and Z is H



( 1 2 )

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The monoazo compound made by coupling diazotised 5-aminoisophthalic acid with m-toluidine was prepared as in Example 1. 22.4g of this monoazo compound was added to water (450ml) and the pH adjusted to 8.0 by addition of 47% sodium hydroxide solution. It was cooled to 0-10°C and a solution of cyanuric chloride (15g) in acetone (150ml) added maintaining the pH at 7-8 and a temperature of 0-10°C. After 3 hours a solution of p-phenylenediamine (3.24g) in acetone (30ml) was added and the reaction mixture stirred at 25°C and pH 7-8 for 18 hours. The reaction mixture was acidified to pH 5 with 2N hydrochloric acid and the product filtered off and pulled dry.

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It was added to water (750ml) and 2-aminoethanol (27.6g) added. The temperature was raised to 65°C and stirred at 65-75°C for 6 hours. After cooling to 20°C the reaction mixture was acidified to pH 5 with concentrated hydrochloric acid and the title product filtered off. It was added to water (400ml) and the pH adjusted to 9.0 with concentrated ammonium hydroxide and the solution dialysed to remove chloride ions, screened and evaporated. The ammonium salt when made into an ink and printed onto plain paper using a thermal ink jet printer gave bright yellow shades with excellent water fastness.

#### Example 20

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Preparation of the compound of Formula (12) in which X is  $N(C_2H_4OH)_2$ , Y is  $CH_3$  and Z is H

In place of the 27.6g of 2-aminoethanol used in Example 19 there was used 47.5g of diethanolamine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with excellent water fastness.

#### Example 21

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Preparation of the compound of Formula (12) in which X is morpholino, Y is  $CH_3$  and Z is H

In place of the 27.6g of 2-aminoethanol used in Example 19 there was used 39.4g of morpholine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gave bright yellow shades with excellent water fastness.

#### Example 22

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Preparation of the compound of Formula (12) in which X is  $NHCH_2CH_2OH$ , and Y and Z are H

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In place of the 22.4g of the monoazo compound used in Example 19 there was used 21.4g of the monoazo compound made by coupling diazotised 5-aminoisophthalic acid with aniline- $\omega$ -methane sulphonate followed by removal of the  $\omega$ -methane sulphonate group as prepared in Example 8. When made into an ink and printed onto plain paper using a thermal ink-jet printing machine it gave bright yellow shades with very good water fastness.

#### Example 23

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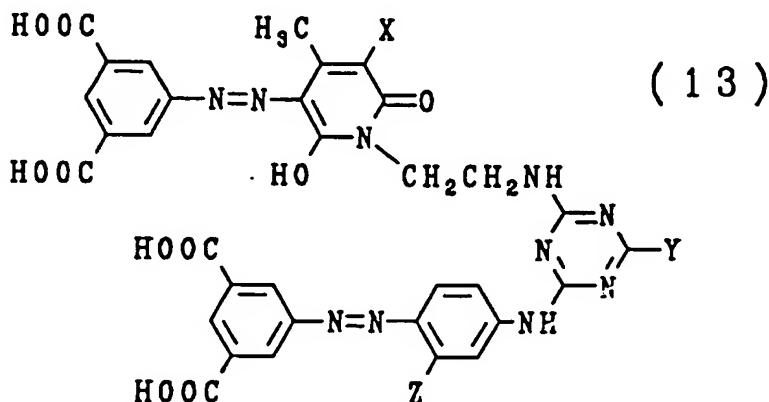
Preparation of the compound of Formula (12) in which X is  $N(C_2H_4OH)_2$ , and Y and Z are H

In place of the 27.6g of 2-aminoethanol used in Example 22 there was used 47.5g of diethanolamine. The ammonium

salt of the title compound when printed onto plain paper using a thermal ink-jet printing machine it gave bright yellow shades having good water fastness.

#### Example 24

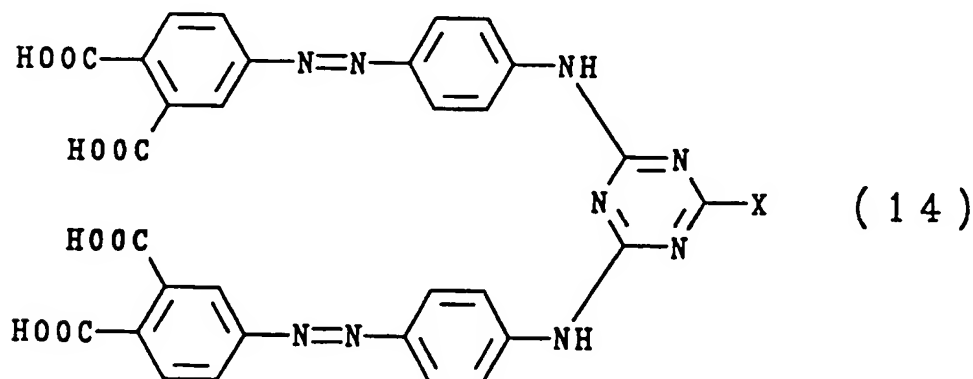
Preparation of the compound of Formula (13) in which X is H, Y is  $\text{NHCH}_2\text{CH}_2\text{OH}$ , and Z is  $\text{CH}_3$



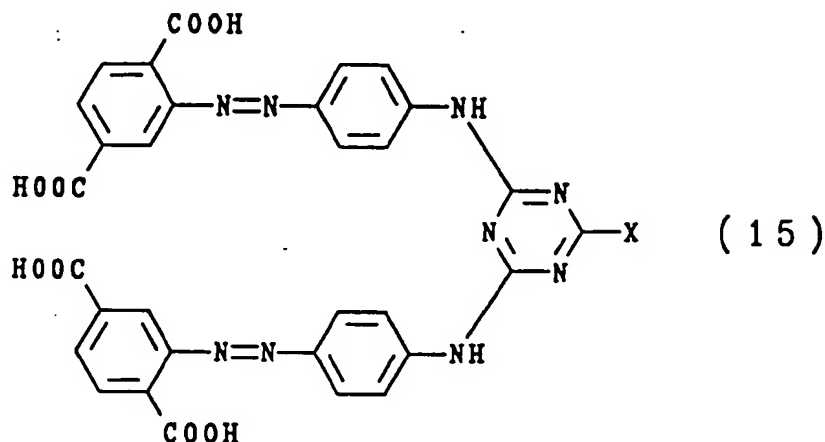
10.8g of the monoazo dye made by coupling diazotised 5-aminoisophthalic acid with 1-(2-aminoethyl)-6-hydroxy-4-methylpyrid-2-one prepared as in Example 2 was stirred in water (1 l) and the pH adjusted to 8.0. It was cooled to 0-5°C and a solution of cyanuric chloride (5.5g) in acetone (100ml) was added at 0-5°C maintaining the pH at 7-8 by addition of 2N sodium hydroxide. After 3 hours, 9g of the monoazo dye made by coupling 5-aminoisophthalic acid with m-toluidine prepared as in Example 1 was added and the mixture warmed to 40-45°C. It was stirred at this temperature, maintaining the pH at 7 for 4 hours. Ethanolamine (20g) was then added, the temperature raised to 80°C and stirred at this temperature for 2 hours. After cooling to 20°C it was acidified to pH 5 with concentrated hydrochloric acid and the product filtered off and padded dry. It was added to water (400ml) and the pH adjusted to 9 by addition of concentrated ammonium hydroxide. The solution was dialysed to remove chloride ions, screened and evaporated to give the ammonium salt of the title product. When made into an ink and printed onto plain paper using a thermal ink jet printer it gave bright yellow shades with very good water fastness.

#### Example 25

Preparation of the compound of Formula (14) in which X is morpholino

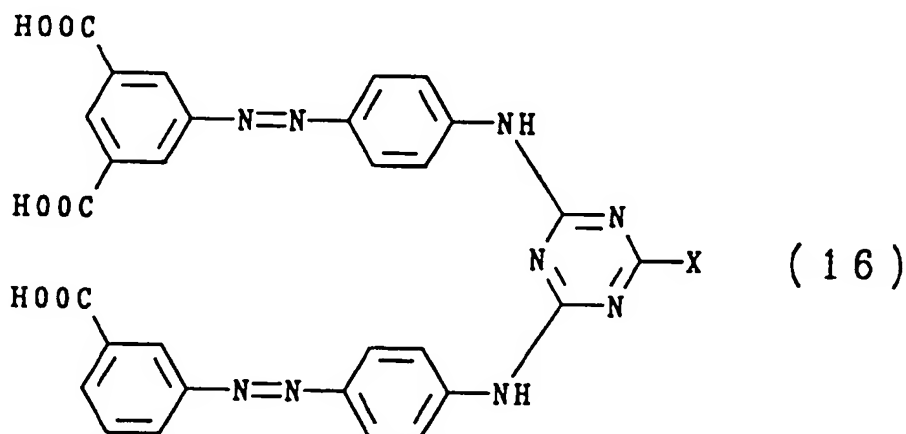


In place of the 5-aminoisophthalic acid used in Example 10 there is used an equal amount of 4-aminophthalic acid. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gives bright yellow shades having very good water fastness.

Example 26Preparation of the compound of Formula (15) in which X is morpholino

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In place of the 5-aminoisophthalic acid used in Example 10 there is used an equal amount of 2-aminoterephthalic acid. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gives bright yellow shades having very good water fastness.

Example 27Preparation of the compound of Formula (16) in which X is morpholino

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3-Aminobenzoic acid (13.7g) is stirred in water (250ml) and the pH adjusted to 8-9 by addition of sodium hydroxide solution. Sodium nitrite (6.9g) is added and the solution added to a mixture of concentrated hydrochloric acid (20ml) and water (100ml) at 0-10°C. After 1 hour at 0-10°C, the excess nitrous acid is removed by addition of a little sulphamic acid.

55

Aniline ω-methane sulphonate (21g) is added to water (150ml) to dissolve. The solution is added to the above diazo solution at 0-10°C and pH 7. The mixture is stirred at 20°C for 18 hours. The product is salted to 20% using sodium chloride, stirred 1 hour and acidified to pH 4 with concentrated hydrochloric acid and then filtered.

The paste is added to a mixture of water (700ml) and sodium hydroxide (40g) and heated at 70-80°C for 3 hours. It is cooled to 20°C and salted to 20% using sodium chloride and acidified to pH 3 using concentrated hydrochloric acid. The product is filtered and dried to give the monoazo compound (A).

5-aminoisophthalic acid is diazotised and coupled onto aniline-ω-methane sulphonate as in Example 8. It is then

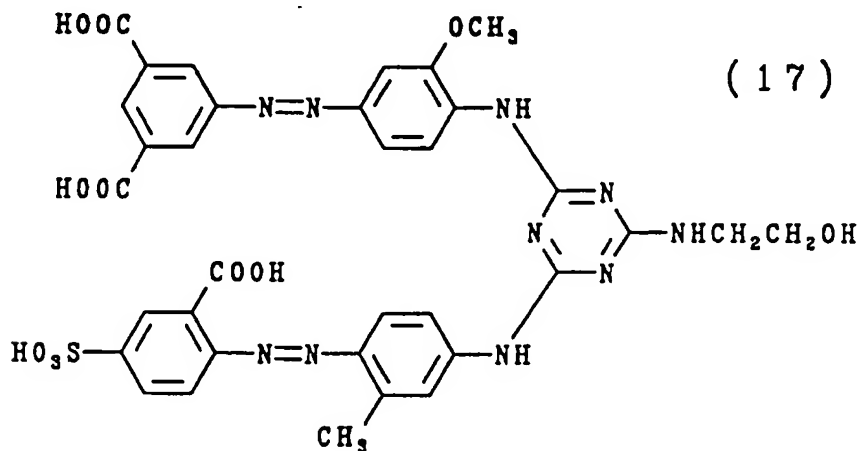
heated with aqueous sodium hydroxide to remove the  $\omega$ -methane sulphonate group as in Example 8 and 7.62g (1 equivalent) of this product condensed with cyanuric chloride as described in Example 8. After 1 hour, 6.5g (1 equivalent) of the above monoazo compound (A) in water (500ml) is added. The pH is adjusted to 8 and the reaction mixture stirred at 25-30°C for 18 hours. The pH is adjusted to 5.0 with concentrated hydrochloric acid and the product filtered.

The product is added to water (500g) and morpholine (14.3g) added and the mixture warmed to 80°C. After stirring at 80°C for 4 hours, the mixture is salted to 30% with ammonium chloride and then cooled to 20°C and filtered.

The ammonium salt when made into an ink and printed onto plain paper using a thermal ink jet printer gives bright yellow shades with very good water fastness.

#### Example 28

##### Preparation of the compound of Formula (17)



2-Amino-5-sulphobenzoic acid (21.7g) was added to a mixture of water (300ml) and concentrated hydrochloric acid (30ml) and the mixture cooled to 0-10°C. A solution of sodium nitrite (7.0g) in water (50ml) was added dropwise and the mixture stirred at 0-10°C for 1 hour. The slight excess of nitrous acid was removed with sulphamic acid and then the mixture added slowly to a solution of m-toluidine (10.7g) in water (200ml) and concentrated hydrochloric acid (12.5ml) at 0-10°C. The pH was adjusted to 4.0 and the mixture stirred for 18 hours at 0-10°C. The monoazo compound was filtered off and dried.

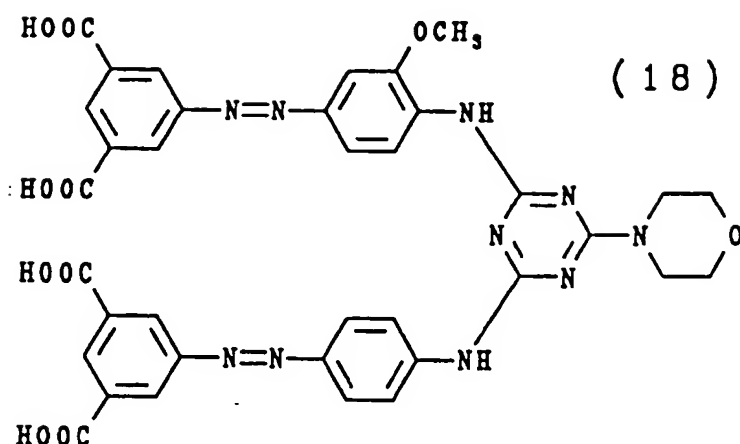
6.3g of the monoazo compound prepared from 5-aminoisophthalic acid and o-anisidine prepared as in Example 17 was added to water (500ml) and the pH adjusted to 8.0 by addition of 47% sodium hydroxide solution. It was cooled to 0-10°C and a solution of cyanuric chloride (3.69g) in acetone (50ml) was added maintaining the pH at 7-8 and a temperature of 0-10°C. After 30 minutes 6.7g of the monoazo compound prepared above from 2-amino-5-sulphobenzoic acid and m-toluidine in water (500ml) was added at pH 8.0 and the reaction mixture warmed to 40°C and stirred at this temperature for 4 hours maintaining the pH at 7-8.

2-Aminoethanol (8g) was then added and the mixture heated to 80°C. After stirring at 80°C for 4 hours the pH was adjusted to 7.0 and salted to 20% using sodium chloride. The product was filtered and washed with saturated brine.

It was converted to the ammonium salt as in Example 1, dialysed, screened and evaporated. When made into an ink and printed onto plain paper using a thermal ink jet printer it gave bright yellow shades with high water fastness.

#### Example 29

##### Preparation of the compound of Formula (18)



In place of the 6.7g of the monoazo compound derived from 2-amino-5-sulphobenzoic acid and m-toluidine used in Example 28 there is used 5.7g of the monoazo compound from 5-aminoisophthalic acid and aniline as prepared in Example 8 and in place of the 8g of 2-aminoethanol there is used 11g of morpholine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink jet printing machine gives bright yellow shades with very good water fastness.

#### Example 30

Preparation of the compound of Formula (12) in which X is morpholino, Y is H and Z are CO<sub>2</sub>H

In place of the 3.24g of p-phenylenediamine used in Example 22 there is used 4.6g of 2,5-diaminobenzoic acid and in place of the 27.6g of 2-aminoethanol there is used 39.3g of morpholine. The ammonium salt of the title compound when made into an ink and printed onto plain paper using a thermal ink-jet printing machine gives bright yellow shades having high water fastness.

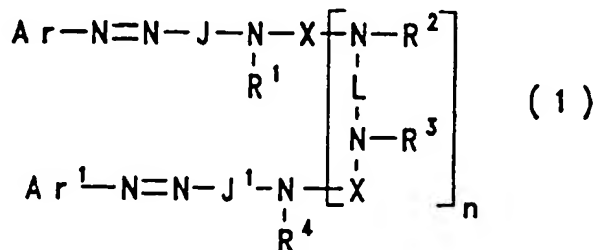
#### Example 31

In place of the 10g of 2-aminoethanol used in Example 1 there is used 10g of 4-(aminomethyl)benzoic acid. The product as the ammonium salt when made into an ink and printed onto plain paper using a thermal ink-jet printer gives bright yellow shades with excellent water fastness.

#### Claims

Claims for the following Contracting States : AT, BE, CH, LI, DE, FR, GB, GR, IT, LU, NL, SE

1. An anionic azo compound which, in the free acid form, has the Formula (1):

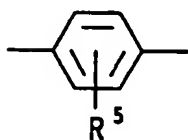


wherein:

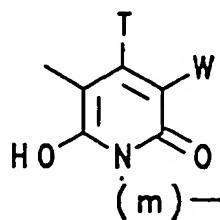
Ar and Ar<sup>1</sup> are each independently aryl or substituted aryl providing at least one of Ar and

J and J<sup>1</sup>

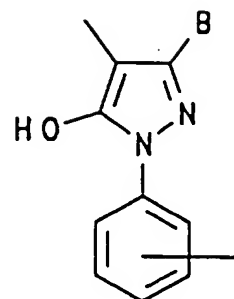
Ar<sup>1</sup> has at least one substituent selected from COOH and COSH;  
are each independently of formula (2), (3) or (4):



( 2 )



( 3 )



( 4 )

each R<sup>5</sup>R<sup>6</sup>

each T

each W

each m

B

R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, R<sup>10</sup> and R<sup>11</sup>

L

n

each X

is independently selected from H, alkyl, substituted alkyl, alkoxy, halogen, CN, ureido and NHCOR<sup>6</sup>;

is H, alkyl, substituted alkyl, aryl, substituted aryl, aralkyl or substituted aralkyl;

is independently alkyl;

is independently selected from H, CN, CONR<sup>10</sup>R<sup>11</sup>, pyridinium and COOH;

is an alkylene chain having 2 to 8 carbon atoms;

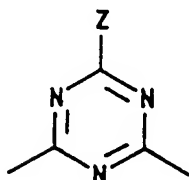
is H, alkyl or COOH;

are each independently H, alkyl or substituted alkyl;

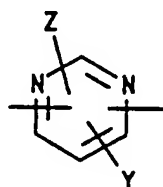
is a divalent organic linking group;

is 0 or 1;

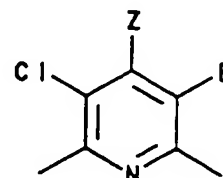
is independently carbonyl or a group of the Formula (5), (6) or (7):



( 5 )



( 6 )



( 7 )

Z

Y

E

R<sup>7</sup>, R<sup>8</sup> and R<sup>9</sup>

is OR<sup>7</sup>, SR<sup>7</sup> or NR<sup>8</sup>R<sup>9</sup>;

is H, Cl, CN or Z;

is Cl or CN;

are independently H, alkenyl, substituted alkenyl, alkyl, substituted alkyl, aryl, substituted aryl, aralkyl or substituted aralkyl, or R<sup>8</sup> and R<sup>9</sup> together with the nitrogen atom to which they are attached form a 5 or 6 membered ring;

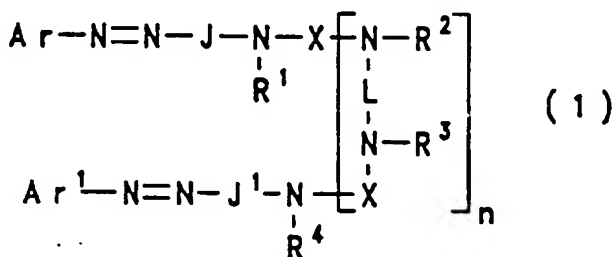
provided (i) if the compound of Formula (1) has no -SO<sub>3</sub>H groups then it has at least two groups selected from -COOH and -COSH; and (ii) the compound of Formula (1) has at least as many groups selected from -COOH and -COSH as -SO<sub>3</sub>H groups.



2. A compound according to Claim 1 having at least as many -COOH as -SO<sub>3</sub>H groups.
3. A compound according to Claim 1 having no -SO<sub>3</sub>H groups and at least two -COOH groups.
- 5 4. A compound according to Claim 3 having at least three -COOH groups.
5. A compound according to any preceding claim wherein at least one of the Ar and Ar<sup>1</sup> has at least one -COOH substituent.
- 10 6. A compound according to Claim 5 wherein each of Ar and Ar<sup>1</sup> has at least one -COOH substituent.
7. A compound according to Claim 6 wherein each of Ar and Ar<sup>1</sup> has at least two -COOH substituents.
8. A compound according to Claim 7 wherein each of Ar and Ar<sup>1</sup> is dicarboxyphenyl.
- 15 9. A compound according to any preceding claim wherein X is a group of Formula (5) and Z is selected from -NHC<sub>2</sub>H<sub>4</sub>OH, -N(C<sub>2</sub>H<sub>4</sub>OH)<sub>2</sub>, -NH(C<sub>1-6</sub>-alkyl) and morpholino.

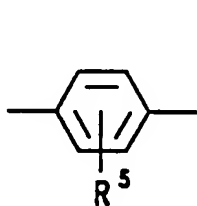
20 Claims for the following Contracting State: ES

1. A process for the preparation of an anionic azo compound which, in the free acid form, has the Formula (1):

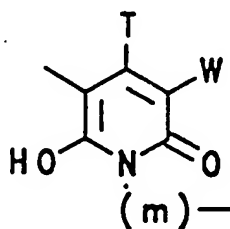


wherein:

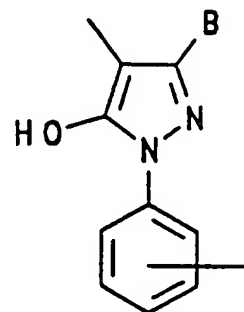
Ar and Ar<sup>1</sup> are each independently aryl or substituted aryl providing at least one of Ar and Ar<sup>1</sup> has at least one substituent selected from -COOH and -COSH;  
 J and J<sup>1</sup> are each independently of formula (2), (3) or (4):



(2)



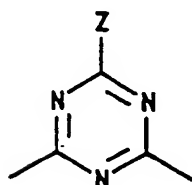
(3)



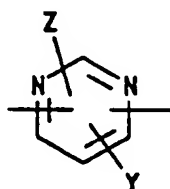
(4)

each R<sup>5</sup> is independently selected from H, alkyl, substituted alkyl, alkoxy, halogen, CN, ureido and -NHCOR<sup>6</sup>;  
 R<sup>6</sup> is H, alkyl, substituted alkyl, aryl, substituted aryl, aralkyl or substituted aralkyl;

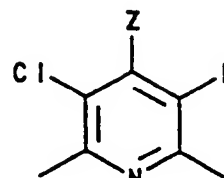
each T is independently alkyl;  
 each W is independently selected from H, CN,  $-\text{CONR}^{10}\text{R}^{11}$ , pyridinium and  $-\text{COOH}$ ;  
 each m is an alkylene chain having 2 to 8 carbon atoms;  
 B is H, alkyl or  $-\text{COOH}$ ;  
 5  $\text{R}^1, \text{R}^2, \text{R}^3, \text{R}^4, \text{R}^{10}$  and  $\text{R}^{11}$  are each independently H, alkyl or substituted alkyl;  
 L is a divalent organic linking group;  
 n is 0 or 1;  
 each X is independently carbonyl or a group of the Formula (5), (6) or (7):



(5)



(6)



(7)

Z is  $\text{OR}^7$ ,  $\text{SR}^7$  or  $\text{NR}^8\text{R}^9$ ;  
 Y is H, Cl, CN or Z;  
 E is Cl or CN;  
 25  $\text{R}^7, \text{R}^8$  and  $\text{R}^9$  are independently H, alkenyl, substituted alkenyl, alkyl, substituted alkyl, aryl, substituted aryl, aralkyl or substituted aralkyl, or  
 $\text{R}^8$  and  $\text{R}^9$  together with the nitrogen atom to which they are attached form a 5 or 6 membered ring;

30 provided (i) if the compound of Formula (1) has no  $-\text{SO}_3\text{H}$  groups then it has at least two groups selected from  $-\text{COOH}$  and  $-\text{COSH}$ ; and (ii) the compound of Formula (1) has at least as many groups selected from  $-\text{COOH}$  and  $-\text{COSH}$  as  $-\text{SO}_3\text{H}$  groups;  
 which comprises

- 35 (a) reacting the monoazo amines,  $\text{Ar-N=N-J-NR}^1\text{H}$  and  $\text{Ar}^1\text{-N=N-J}^1\text{-NR}^4\text{H}$ , in either order or simultaneously with a compound of the formula  $\text{Cl-X-(NR}^2\text{-L-NR}^3\text{-X)}_n\text{-Cl}$ , wherein Ar,  $\text{Ar}^1$ ,  $\text{R}^1$  to  $\text{R}^4$ , J,  $\text{J}^1$ , L and n are as hereinbefore defined and X is of Formula (5), (6) or (7) except that in each case Z is replaced by Cl; and  
 (b) reacting the product from (a) with a compound ZH, in which Z is as hereinbefore defined.

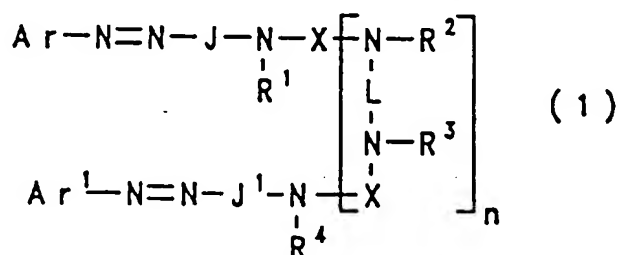
- 40 2. A process according to Claim 1 wherein the compounds  $\text{Ar-N=N-J-NR}^1\text{H}$ ,  $\text{Ar}^1\text{-N=N-J}^1\text{-NR}^4\text{H}$  and  $\text{Cl-X-(NR}^2\text{-L-NR}^3\text{-X)}_n\text{-Cl}$  are selected so that the compound of Formula (1) has at least as many  $-\text{COOH}$  as  $-\text{SO}_3\text{H}$  groups.
- 45 3. A process according to Claim 1 wherein the compounds  $\text{Ar-N=N-J-NR}^1\text{H}$ ,  $\text{Ar}^1\text{-N=N-J}^1\text{-NR}^4\text{H}$  and  $\text{Cl-X-(NR}^2\text{-L-NR}^3\text{-X)}_n\text{-Cl}$  are selected so that the compound of Formula (1) has no  $-\text{SO}_3\text{H}$  groups and at least two  $-\text{COOH}$  groups.
4. A process according to Claim 3 wherein the compounds  $\text{Ar-N=N-J-NR}^1\text{H}$ ,  $\text{Ar}^1\text{-N=N-J}^1\text{-NR}^4\text{H}$  and  $\text{Cl-X-(NR}^2\text{-L-NR}^3\text{-X)}_n\text{-Cl}$  are selected so that the compound of Formula (1) has at least three  $-\text{COOH}$  groups.
- 50 5. A process according to any preceding claim wherein at least one of Ar and  $\text{Ar}^1$  has at least one  $-\text{COOH}$  substituent.
6. A process according to Claim 5 wherein each of Ar and  $\text{Ar}^1$  has at least one  $-\text{COOH}$  substituent.
7. A process according to Claim 6 wherein each of Ar and  $\text{Ar}^1$  has at least two  $-\text{COOH}$  substituents.
- 55 8. A process according to Claim 7 wherein each of Ar and  $\text{Ar}^1$  is dicarboxyphenyl.

9. A process according to any preceding claim wherein X is a group of Formula (5) and Z is selected from  $\text{-NHC}_2\text{H}_4\text{OH}$ ,  $\text{-N(C}_2\text{H}_4\text{OH)}_2$ ,  $\text{-NH(C}_{1-6}\text{-alkyl)}$  and morpholino.

## 5 Patentansprüche

Patentansprüche für folgende Vertragsstaaten: AT, BE, CH, LI, DE, FR, GB, GR, IT, LU, NL, SE

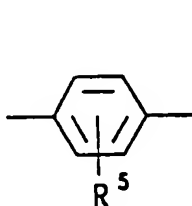
- 10 1. Anionische Azo-Verbindung, die in Form der freien Säure die folgende Formel (1) aufweist:



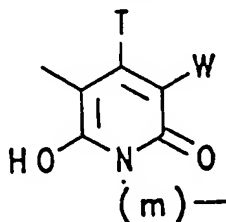
in der:

Ar und Ar<sup>1</sup> jeweils unabhängig voneinander für Aryl oder substituiertes Aryl stehen, mit der Maßgabe, daß mindestens einer der Substituenten Ar und Ar<sup>1</sup> mindestens einen unter COOH und COSH ausgewählten Substituenten aufweist;

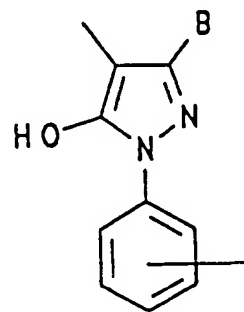
J und J<sup>1</sup> jeweils unabhängig voneinander die Formel (2), (3) oder (4) aufweisen:



(2)



(3)



(4)

R<sup>5</sup> jeweils unabhängig unter H, Alkyl, substituiertem Alkyl, Alkoxy, Halogen, CN, Ureido und NHCOR<sup>6</sup> ausgewählt ist;

R<sup>6</sup> für H, Alkyl, substituiertes Alkyl, Aryl, substituiertes Aryl, Aralkyl oder substituiertes Aralkyl steht;

T jeweils unabhängig für Alkyl steht;

W jeweils unabhängig unter H, CN, CONR<sup>10</sup>R<sup>11</sup>, Pyridinium und COOH ausgewählt ist;

m jeweils für eine Alkylen-Kette mit 2 bis 8 Kohlenstoffatomen steht;

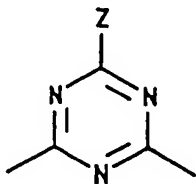
B für H, Alkyl oder COOH steht;

R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, R<sup>10</sup> und R<sup>11</sup> jeweils unabhängig voneinander für H, Alkyl oder substituiertes Alkyl stehen;

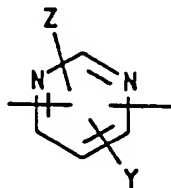
L für eine zweiwertige organische Verknüpfungsgruppe steht;

n für 0 oder 1 steht;

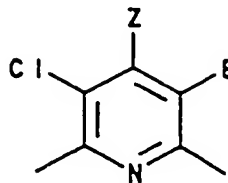
X jeweils unabhängig für Carbonyl oder eine Gruppe mit der Formel (5), (6) oder (7) steht:



( 5 )



( 6 )



( 7 )

Z für  $\text{CH}^7$ ,  $\text{SR}^7$  oder  $\text{NR}^8\text{R}^9$  steht;

Y für H, Cl, CN oder Z steht;

E für Cl oder CN steht;

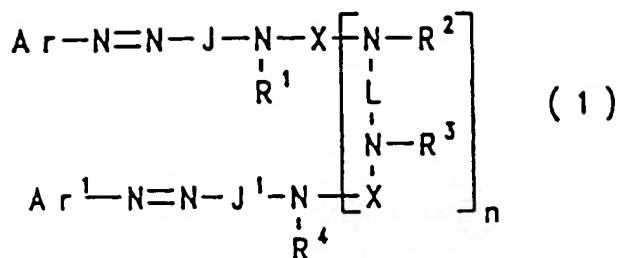
$\text{R}^7$ ,  $\text{R}^8$  und  $\text{R}^9$  unabhängig voneinander für H, Alkenyl, substituiertes Alkenyl, Alkyl, substituiertes Alkyl, Aryl, substituiertes Aryl, Aralkyl oder substituiertes Aralkyl stehen, oder  $\text{R}^8$  und  $\text{R}^9$  zusammen mit dem Stickstoffatom, an das sie gebunden sind, einen 5- oder 6-gliedrigen Ring bilden;

mit der Maßgabe, daß (i) die Verbindung mit der Formel (1) dann mindestens zwei unter -COOH und -COSH ausgewählte Gruppen aufweist, wenn sie keine -SO<sub>3</sub>H-Gruppen aufweist; und (ii) die Verbindung mit der Formel (1) mindestens so viele unter -COOH und -COSH ausgewählte Gruppen aufweist wie -SO<sub>3</sub>H-Gruppen.

2. Verbindung nach Anspruch 1, die mindestens so viele -COOH-Gruppen wie -SO<sub>3</sub>H-Gruppen aufweist.
3. Verbindung nach Anspruch 1, die keine -SO<sub>3</sub>H-Gruppen und mindestens zwei -COOH-Gruppen aufweist.
4. Verbindung nach Anspruch 3, die mindestens drei -COOH-Gruppen aufweist.
5. Verbindung nach einem der vorhergehenden Ansprüche, wobei mindestens einer der Substituenten Ar und Ar<sup>1</sup> mindestens einen -COOH-Substituenten aufweist.
6. Verbindung nach Anspruch 5, wobei jeder Substituenten Ar und Ar<sup>1</sup> mindestens einen -COOH-Substituenten aufweist.
7. Verbindung nach Anspruch 6, wobei jeder der Substituenten Ar und Ar<sup>1</sup> mindestens zwei -COOH-Substituenten aufweist.
8. Verbindung nach Anspruch 7, wobei jeder der Substituenten Ar und Ar<sup>1</sup> Dicarboxyphenyl ist.
9. Verbindung nach einem der vorhergehenden Ansprüche, wobei X für eine Gruppe mit der Formel (5) steht und Z unter -NHC<sub>2</sub>H<sub>4</sub>OH, -N(C<sub>2</sub>H<sub>4</sub>OH)<sub>2</sub>, -NH(C<sub>1-6</sub>-alkyl) und Morpholino ausgewählt ist.

Patentansprüche für folgend n Vertragsstaat: ES

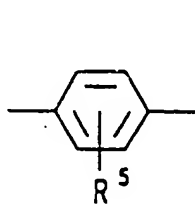
1. Verfahren zur Herstellung einer anionischen Azo-Verbindung, die in Form der freien Säure die folgende Formel (1) aufweist:



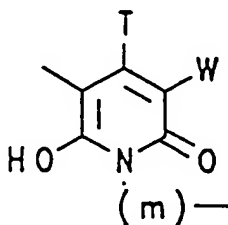
in der:

Ar und Ar<sup>1</sup> jeweils unabhängig voneinander für Aryl oder substituiertes Aryl stehen, mit der Maßgabe, daß mindestens einer der Substituenten Ar und Ar<sup>1</sup> mindestens einen unter COOH und COSH ausgewählten Substituenten aufweist;

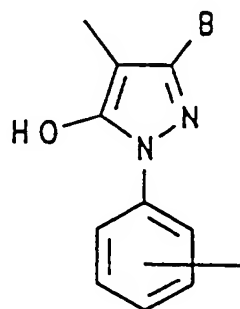
J und J<sup>1</sup> jeweils unabhängig voneinander die Formel (2), (3) oder (4) aufweisen:



(2)



(3)



(4)

R<sup>5</sup> jeweils unabhängig unter H, Alkyl, substituiertem Alkyl, Alkoxy, Halogen, CN, Ureido und -NHCOR<sup>6</sup> ausgewählt ist;

R<sup>6</sup> für H, Alkyl, substituiertes Alkyl, Aryl, substituiertes Aryl, Aralkyl oder substituiertes Aralkyl steht;

T jeweils unabhängig für Alkyl steht;

W jeweils unabhängig unter H, CN, -CONR<sup>10</sup>R<sup>11</sup>, Pyridinium und -COOH ausgewählt ist;

m jeweils für eine Alkylen-Kette mit 2 bis 8 Kohlenstoffatomen steht;

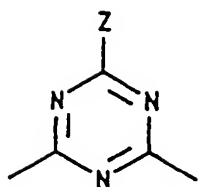
B für H, Alkyl oder -COOH steht;

R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, R<sup>10</sup> und R<sup>11</sup> jeweils unabhängig voneinander für H, Alkyl oder substituiertes Alkyl stehen;

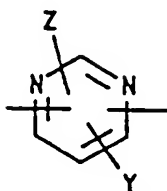
L für eine zweiwertige organische Verknüpfungsgruppe steht;

n für 0 oder 1 steht;

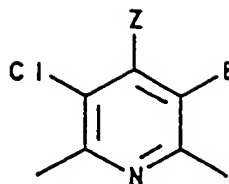
X jeweils unabhängig für Carbonyl oder eine Gruppe mit der Formel (5), (6) oder (7) steht:



( 5 )



( 6 )



( 7 )

Z für  $OR^7$ ,  $SR^7$  oder  $NR^8R^9$  steht;

Y für H, Cl, CN oder Z steht;

E für Cl oder CN steht;

$R^7$ ,  $R^8$  und  $R^9$  unabhängig voneinander für H, Alkenyl, substituiertes Alkenyl, Alkyl, substituiertes Alkyl, Aryl, substituiertes Aryl, Arylalkyl oder substituiertes Arylalkyl stehen, oder  $R^8$  und  $R^9$  zusammen mit dem Stickstoffatom, an das sie gebunden sind, einen 5- oder 6-gliedrigen Ring bilden;

mit der Maßgabe, daß (i) die Verbindung mit der Formel (1) dann mindestens zwei unter -COOH und -COSH ausgewählte Gruppen aufweist, wenn sie keine -SO<sub>3</sub>H-Gruppen aufweist; und (ii) die Verbindung mit der Formel (1) mindestens so viele unter -COOH und -COSH ausgewählte Gruppen aufweist wie -SO<sub>3</sub>H-Gruppen, bei dem

(a) die Monoazoamine  $Ar-N=N-J-NR^1H$  und  $Ar^1-N=N-J^1-NR^4H$  in beliebiger Reihenfolge oder gleichzeitig mit einer Verbindung mit der Formel  $Cl-X-(NR^2-L-NR^3-X)_n-Cl$  umgesetzt werden, wobei Ar,  $Ar^1$ ,  $R^1$  bis  $R^4$ , J,  $J^1$ , L und n wie oben definiert sind und X die Formel (5), (6) oder (7) hat, mit der Ausnahme, daß in jedem Fall Z durch Cl ersetzt ist; und

(b) das Produkt aus (a) mit einer Verbindung ZH, in der Z wie oben definiert ist, umgesetzt wird.

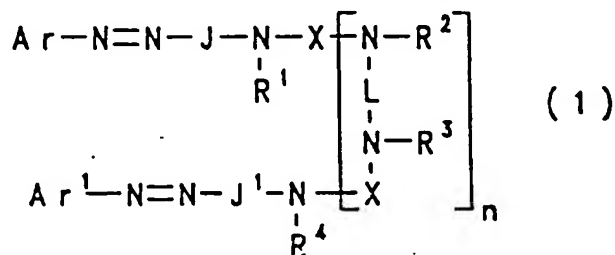
2. Verfahren nach Anspruch 1, wobei die Verbindungen  $Ar-N=N-J-NR^1H$ ,  $Ar^1-N=N-J^1-NR^4H$  und  $Cl-X-(NR^2-L-NR^3-X)_n-Cl$  so ausgewählt sind, daß die Verbindung mit der Formel (1) mindestens so viele -COOH- wie -SO<sub>3</sub>H-Gruppen aufweist.
3. Verfahren nach Anspruch 1, wobei die Verbindungen  $Ar-N=N-J-NR^1H$ ,  $Ar^1-N=N-J^1-NR^4H$  und  $Cl-X-(NR^2-L-NR^3-X)_n-Cl$  so ausgewählt sind, daß die Verbindung mit der Formel (1) keine -SO<sub>3</sub>H-Gruppen und mindestens zwei -COOH-Gruppen aufweist.
4. Verfahren nach Anspruch 3, wobei die Verbindungen  $Ar-N=N-J-NR^1H$ ,  $Ar^1-N=N-J^1-NR^4H$  und  $Cl-X-(NR^2-L-NR^3-X)_n-Cl$  so ausgewählt sind, daß die Verbindung mit der Formel (1) mindestens drei -COOH-Gruppen aufweist.
5. Verfahren nach einem der vorhergehenden Ansprüche, wobei mindestens einer der Substituenten Ar und  $Ar^1$  mindestens einen -COOH-Substituenten aufweist.
6. Verfahren nach Anspruch 5, wobei jeder der Substituenten Ar und  $Ar^1$  mindestens einen -COOH-Substituenten aufweist.
7. Verfahren nach Anspruch 6, wobei jeder der Substituenten Ar und  $Ar^1$  mindestens zwei -COOH-Substituenten aufweist.
8. Verfahren nach Anspruch 7, wobei jeder der Substituenten Ar und  $Ar^1$  Dicarboxyphenyl ist.
9. Verfahren nach einem der vorhergehenden Ansprüche, wobei X für eine Gruppe mit der Formel (5) steht und Z

unter -NHC<sub>2</sub>H<sub>4</sub>OH, -N(C<sub>2</sub>H<sub>4</sub>OH)<sub>2</sub>, -NH(C<sub>1-6</sub>-Alkyl) und Morpholino ausgewählt ist.

# Revendications

Revendications pour les Etats contractants suivants : AT, BE, CH, LI, DE, FR, GB, GR, IT, LU, NL, SE

1. Composé azoïque anionique qui, sous la forme acide libre, répond à la formule (1) :



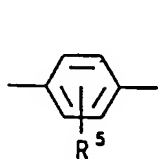
dans laquelle :

Ar et Ar<sup>1</sup>

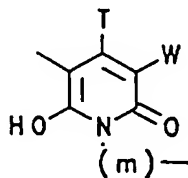
représentent chacun indépendamment un groupe aryle ou aryle substitué, sous réserve qu'au moins un des groupes Ar et Ar<sup>1</sup> porte au moins un substituant choisi entre COOH et COSH ;

J et J<sup>1</sup>

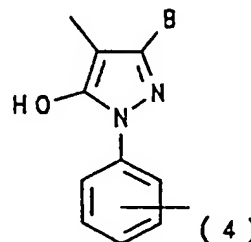
répondent chacun indépendamment à la formule (2), (3) ou (4) :



(2)



(3)



(4)

chaque groupe R<sup>5</sup>

est choisi indépendamment entre H, un groupe alkyle, un groupe alkyle substitué, un groupe alkoxy, un halogène, un groupe CN, un groupe uréido et un groupe NHCOR<sup>6</sup> ;

R<sup>6</sup>

représente H, un groupe alkyle, alkyle substitué, aryle, aryle substitué, aralkyle ou aralkyle substitué

chaque groupe T  
chaque groupe W

représente indépendamment un groupe alkyle,  
est choisi indépendamment entre H, des groupes CN, CONR<sup>10</sup>R<sup>11</sup>, pyridinium et COOH ;

chaque groupe m

représente une chaîne alkylène ayant 2 à 8 atomes de carbone ;

B

représente H, un groupe alkyle ou COOH ;

R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, R<sup>10</sup> et R<sup>11</sup>

représentent chacun indépendamment H, un groupe alkyle ou alkyle substitué ;

L

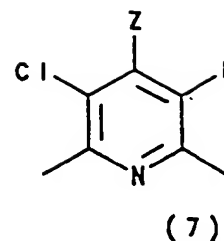
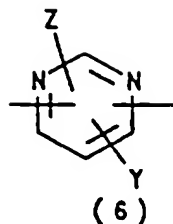
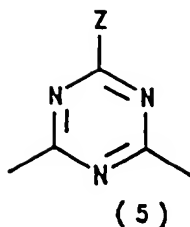
représente un groupe organique divalent de jonction ;

n

est égal à 0 ou 1 ;

chaque groupe X

représente indépendamment un groupe carbonyle ou un groupe de formule (5), (6) ou (7) :



Z  
Y  
E  
R<sup>7</sup>, R<sup>8</sup> et R<sup>9</sup>

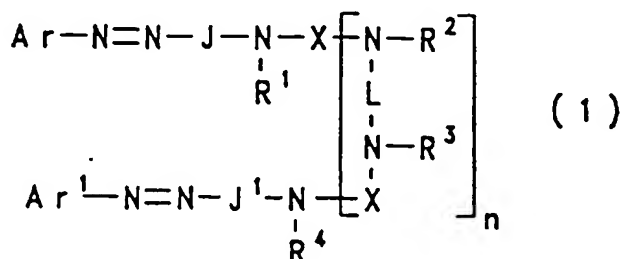
représente un groupe OR<sup>7</sup>, SR<sup>7</sup> ou NR<sup>8</sup>R<sup>9</sup> ;  
représente H, Cl, un groupe CN ou Z ;  
représente Cl ou un groupe CN ;  
représentent indépendamment H, un groupe alcényle, alcényle substitué, alkyle, alkyle substitué, aryle, aryle substitué, aralkyle ou aralkyle substitué, ou bien R<sup>8</sup> et R<sup>9</sup>, conjointement avec l'atome d'azote auquel ils sont fixés, forment un noyau penta- ou hexagonal ;

sous réserve que (i) si le composé de formule (1) ne possède aucun groupe -SO<sub>3</sub>H, il possède alors au moins deux groupes choisis entre les groupes -COOH et -COSH ; et (ii) le composé de formule (1) possède au moins autant de groupes choisis entre les groupes -COOH et -COSH que de groupes -SO<sub>3</sub>H.

2. Composé suivant la revendication 1, possédant au moins autant de groupes -COOH que de groupes -SO<sub>3</sub>H.
3. Composé suivant la revendication 1, ne possédant aucun groupe -SO<sub>3</sub>H et possédant au moins deux groupes -COOH.
4. Composé suivant la revendication 3, possédant au moins trois groupes -COOH.
5. Composé suivant l'une quelconque des revendications précédentes, dans lequel au moins un des groupes Ar et Ar<sup>1</sup> consiste en au moins un substituant -COOH.
6. Composé suivant la revendication 5, dans lequel chacun des groupes Ar et Ar<sup>1</sup> porte au moins un substituant -COOH.
7. Composé suivant la revendication 6, dans lequel chacun des groupes Ar et Ar<sup>1</sup> porte au moins deux substituants -COOH.
8. Composé suivant la revendication 7, dans lequel chacun des groupes Ar et Ar<sup>1</sup> est un groupe dicarboxyphényle.
9. Composé suivant l'une quelconque des revendications précédentes, dans lequel X représente un groupe de formule (5) et Z est choisi entre des groupes -NHC<sub>2</sub>H<sub>4</sub>OH, -N(C<sub>2</sub>H<sub>4</sub>OH)<sub>2</sub>, -NH(alkyle en C<sub>1</sub> à C<sub>6</sub>) et morpholino.

#### Revendications pour l'Etat contractant suivant : ES

1. Procédé de préparation d'un composé azoïque anionique qui, sous la forme d'acide libre, répond à la formule (1) :





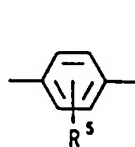
dans laquelle :

Ar et Ar<sup>1</sup>

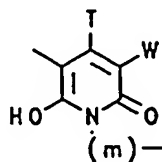
représentent chacun indépendamment un groupe aryle ou aryle substitué, sous réserve qu'au moins un des groupes Ar et Ar<sup>1</sup> porte au moins un substituant choisi entre les groupes -COOH et -COSH ;

J et J<sup>1</sup>

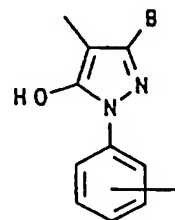
répondent chacun indépendamment à la formule (2), (3) ou (4) :



( 2 )



( 3 )



( 4 )

chaque groupe R<sup>5</sup>

est choisi indépendamment entre H, des groupes alkyle, alkyle substitué, alkoxy, halogéno, CN, uréido et -NHCOR<sup>6</sup> ;

R<sup>6</sup>

représente H, un groupe alkyle, alkyle substitué, aryle, aryle substitué, aralkyle ou aralkyle substitué ;

chaque groupe T  
chaque groupe W

représente indépendamment un groupe alkyle,

est choisi indépendamment entre H, des groupes CN, -CONR<sup>10</sup>R<sup>11</sup>, pyridinium et -COOH ;

chaque groupe m

représente une chaîne alkylène ayant 2 à 8 atomes de carbone ;

B

représente H, un groupe alkyle ou -COOH ;

R<sup>1</sup>, R<sup>2</sup>, R<sup>3</sup>, R<sup>4</sup>, R<sup>10</sup> et R<sup>11</sup>

représentent chacun indépendamment H, un groupe alkyle ou alkyle substitué ;

L

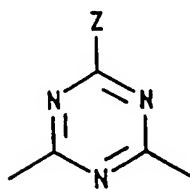
représente un groupe organique divalent de liaison ;

n

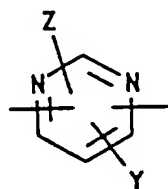
est égal à 0 ou 1 ;

chaque groupe X

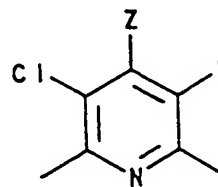
représente indépendamment un groupe carbonyle ou un groupe de formule (5), (6) ou (7) :



( 5 )



( 6 )



( 7 )

Z

représente un groupe OR<sup>7</sup>, SR<sup>7</sup> ou NR<sup>8</sup>R<sup>9</sup> ;

Y

représente H, Cl, un groupe CN ou Z ;

E

représente Cl ou un groupe CN ;

R<sup>7</sup>, R<sup>8</sup> et R<sup>9</sup>

représentent chacun indépendamment H, un groupe alcényle, alcényle substitué, alkyle, alkyle substitué, aryle, aryle substitué, aralkyle ou aralkyle substitué, ou

R<sup>8</sup> et R<sup>9</sup>,

conjointement avec l'atome d'azote auquel ils sont fixés, forment un noyau penta- ou hexagonal ;

sous réserve que (i) si le composé de formule (1) ne comporte aucun groupe -SO<sub>3</sub>H, il possède alors au moins deux groupes choisis entre les groupes -COOH et -COSH ; et (ii) le composé de formule (1) comprend au moins autant de groupes choisis entre les groupes -COOH et -COSH que de groupes -SO<sub>3</sub>H ;

qui comprend

(a) la réaction des mono-azo-amines, de formules Ar-N=N-J-NR<sup>1</sup>H et Ar<sup>1</sup>-N=N-J<sup>1</sup>-NR<sup>4</sup>H, dans l'un ou l'autre

ordre ou simultanément avec un composé de formule  $\text{Cl-X}-(\text{NR}^2\text{-L-NR}^3\text{-X})_n\text{-Cl}$ , dans laquelle Ar, Ar<sup>1</sup>, R<sup>1</sup> à R<sup>4</sup>, J, J<sup>1</sup>, L et n répondent aux définitions précitées et X répond à la formule (5), (6) ou (7), sauf que, dans chaque cas, Z est remplacé par Cl ; et

(b) la réaction du produit de (a) avec un composé de formule ZH, dans laquelle Z répond à la définition précitée.

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2. Procédé suivant la revendication 1, dans lequel les composés de formules  $\text{Ar-N=N-J-NR}^1\text{H}$ ,  $\text{Ar}^1\text{-N=N-J}^1\text{-NR}^4\text{H}$  et  $\text{Cl-X}-(\text{NR}^2\text{-L-NR}^3\text{-X})_n\text{-Cl}$  sont choisis de telle sorte que le composé de formule (1) comprenne au moins autant de groupes -COOH que de groupes -SO<sub>3</sub>H.
- 10 3. Procédé suivant la revendication 1, dans lequel les composés de formules  $\text{Ar-N=N-J-NR}^1\text{H}$ ,  $\text{Ar}^1\text{-N=N-J}^1\text{-NR}^4\text{H}$  et  $\text{Cl-X}-(\text{NR}^2\text{-L-NR}^3\text{-X})_n\text{-Cl}$  sont choisis de telle sorte que le composé de formule (1) ne comprenne aucun groupe -SO<sub>3</sub>H et comprenne au moins deux groupes -COOH.
- 15 4. Procédé suivant la revendication 3, dans lequel les composés de formules  $\text{Ar-N=N-J-NR}^1\text{H}$ ,  $\text{Ar}^1\text{-N=N-J}^1\text{-NR}^4\text{H}$  et  $\text{Cl-X}-(\text{NR}^2\text{-L-NR}^3\text{-X})_n\text{-Cl}$  sont choisis de telle sorte que le composé de formule (1) comprenne au moins trois groupes -COOH.
5. Procédé suivant l'une quelconque des revendications précédentes, dans lequel au moins un des groupes Ar et Ar<sup>1</sup> comprend au moins un substituant -COOH.
- 20 6. Procédé suivant la revendication 5, dans lequel chacun des groupes Ar et Ar<sup>1</sup> comprend au moins un substituant -COOH.
7. Procédé suivant la revendication 6, dans lequel chacun des groupes Ar et Ar<sup>1</sup> comprend au moins deux substituants -COOH.
- 25 8. Procédé suivant la revendication 7, dans lequel chacun des groupes Ar et Ar<sup>1</sup> est un groupe dicarboxyphényle.
9. Procédé suivant l'une quelconque des revendications précédentes, dans lequel X représente un groupe de formule (5) et Z est choisi entre des groupes -NHC<sub>2</sub>H<sub>4</sub>OH, -N(C<sub>2</sub>H<sub>4</sub>OH)<sub>2</sub>, -NH(alkyle en C<sub>1</sub> à C<sub>6</sub>) et morpholino.
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